

I claim:

1. A method of making a material having a unique visual appearance comprising the steps of:

- 5 providing a pile material comprising a base web portion and a plurality of pile yarns extending outwardly from the base web portion at a first position relative to the base web portion, wherein at least a plurality of the pile yarns are dyed pile yarns having a lower portion proximate to the base web portion that is a first color and an upper
- 10 portion remote from the base web portion that is a second color, with the second color being visually distinct from the first color; and
- treating the material to deflect at least a plurality of the pile yarns from their first position such that the lower portions of at least a plurality of said dyed pile yarns are exposed.

15

2. The method of Claim 1, wherein said step of providing a pile material comprises dyeing the upper portion of at least some of said pile yarns.

- 20 3. The method of Claim 2, wherein said step of dyeing is performed by a process selected from the group consisting of transfer printing, spraying, misting, engraved roll dye application, and screen printing.

- 25 4. The method of Claim 3, wherein said step of dyeing is performed by transfer printing.

5. The method of Claim 1, wherein said step of treating is performed by a process selected from the group consisting of contacting the fabric with a pattern of hot gas, contacting the material with a pressurized liquid, and contacting the fabric with a brush.

5

6. The method of Claim 5, wherein said step of treating is performed by contacting the material with a pattern of hot gas.

7. The method of Claim 1, wherein said step of dyeing is performed by transfer printing and said step of treating is performed by contacting the fabric with a pattern of hot air.

8. The method of Claim 1, wherein said step of treating the material to deflect at least a plurality of the pile yarns comprises a process selected from the group consisting of deflecting pile yarns to a different angle, deflecting yarns to a different lateral position, or combinations thereof.

9. The method of Claim 8, wherein said step of treating the material to deflect at least a plurality of the pile yarns is performed such that at least some of the pile yarns are at a position at least 30 degrees different from said first pile position.

10. The method of Claim 9, wherein the angle of pile yarns that were deflected is at least about 30 degrees different from the angle of the pile yarns in the first pile position.

11. The method of Claim 9, wherein the angle of pile yarns that were deflected is at least about 50 degrees different from the angle of the pile yarns in the first pile position.

5 12. The method of Claim 9, wherein the angle of pile yarns that were deflected is at least about 70 degrees different from the angle of the pile yarns in the first pile position.

10 13. The method of Claim 9, wherein the angle of pile yarns that were deflected is at least about 90 degrees different from the angle of the pile yarns in the first pile position.

15 14. The method of Claim 9, wherein the lateral position of pile yarns that were deflected is at least about 30 degrees different from the lateral position of the pile yarns in the first pile position.

20 15. The method of Claim 9, wherein the lateral position of pile yarns that were deflected is at least about 50 degrees different from the lateral position of the pile yarns in the first pile position.

16. The method of Claim 9, wherein the lateral position of pile yarns that were deflected is at least about 70 degrees different from the lateral position of the pile yarns in the first pile position.

25 17. The method of Claim 9, wherein the lateral position of pile yarns that were deflected is at least about 90 degrees different from the lateral position of the pile yarns in the first pile position.

18. The method of Claim 9, wherein the lateral position of pile yarns that were deflected is at least about 135 degrees different from the lateral position of the pile yarns in the first pile position.

5 19. The method of Claim 1, wherein said step of providing a pile material comprises providing a textile fabric.

20. The method of Claim 1, wherein at least some of said pile yarns comprise a thermoplastic material, and said step of treating
10 comprises treating the material at a temperature greater than a heat set temperature for the thermoplastic material, to thereby provide a durable pattern to the fabric.

15 21. A material comprising a base web portion and a plurality of pile yarns having a lower portion which is a first color and an upper portion which is a second color, said second color being visually distinct from said first color, wherein a first plurality of said pile yarns extends from said base web portion at a first position, and a second
20 plurality of said pile yarns extends from said base web portion at a second position, and said second position is different from said first angle such that the first color is exposed where said first plurality of pile yarns is adjacent to said second plurality of pile yarns.

25 22. The material according to Claim 21, wherein said base web portion is made from the group consisting of knit fabrics, woven fabrics, nonwoven fabrics and films.

23. The material according to Claim 21, wherein said pile yarns are integrally formed with the base web portion.

24. The material according to Claim 21, wherein said pile
5 yarns are formed by a method selected from the group consisting of integral pile formation, napping, tufting, sanding, flocking and adhesive pile application.

25. The material according to Claim 21, wherein at least
10 some of said pile yarns comprise thermoplastic fibers.

26. The material according to Claim 21, wherein substantially all of said pile yarns comprise thermoplastic fibers.

15 27. The material according to Claim 21, wherein the difference between said first position and said second position is at least about 30 degrees.

28. The material according to Claim 21, wherein the
20 difference between said first position and said second position is at least about 60 degrees.

29. The material according to Claim 21, wherein the
difference between said first position and said second position is at
25 least about 90 degrees.

30. The material according to Claim 21, wherein the first position and second position are different in either the angle direction, the lateral direction, or a combination thereof.

5 31. The material according to Claim 21, wherein said first plurality of pile yarns and said second plurality of pile yarns define a pattern, and wherein said pattern is durable.

32. A textile fabric having a unique visual appearance
10 comprising:
a base web portion;
a plurality of pile yarns extending outwardly from the base web portion, and defining a first region of pile yarns extending outwardly from the base web portion at a first position and a second region of
15 pile yarns adjacent to said first region, with the pile yarns of the second region extending outwardly from the base web portion at a second position, with said second position being either at a different angle or a different lateral position from said first position, wherein at least a plurality of said pile yarns have lower portions proximate to
20 said base web portion that are a first color, and upper portions remote from said base web portion that are a second color, with said first color being visually distinct from said second color.

33. The fabric according to Claim 32, wherein said first and
25 second regions define a pattern on said fabric, and said pattern is durable.

34. The fabric according to Claim 32, wherein said fabric is selected from the group consisting of woven, knit and nonwoven fabrics.

5 35. The fabric according to Claim 32, wherein at least a plurality of said pile yarns comprise thermoplastic material.

36. The fabric according to Claim 32, wherein the lower portions of at least some of said pile yarns are exposed where said
10 first region is adjacent to said second region.

37. A method of making a material having a unique visual appearance comprising the steps of:

providing a pile material comprising a base web portion and a
15 plurality of pile yarns extending outwardly from the base web portion at a first position relative to the base web portion, wherein at least a plurality of the pile yarns are dyed pile yarns having a lower portion proximate to the base web portion that is a first color and an upper portion remote from the base web portion that is a second color, with
20 the second color being visually distinct from the first color; and

treating the material such that the lower portions of at least a plurality of said dyed pile yarns are exposed.

38. The method of Claim 37, wherein said step of providing a
25 pile material comprises dyeing the upper portion of at least some of said pile yarns.

39. The method of Claim 38, wherein said step of dyeing is performed by a process selected from the group consisting of transfer printing, spraying, misting, engraved roll dye application, and screen printing.

5

40. The method of Claim 39, wherein said step of dyeing is performed by transfer printing.

41. The method of Claim 37, wherein said step of treating is performed by a process selected from the group consisting of contacting the fabric with a pattern of hot gas, contacting the material with a pressurized liquid, and contacting the fabric with a brush.

42. The method of Claim 41, wherein said step of treating is performed by contacting the material with a pattern of hot gas.

43. The method of Claim 37, wherein said step of dyeing is performed by transfer printing and said step of treating is performed by contacting the fabric with a pattern of hot air.

20

44. The method of Claim 37, wherein said step of treating the material comprises deflecting at least a plurality of the pile yarns by a process selected from the group consisting of deflecting pile yarns to a different angle, deflecting yarns to a different lateral position, or combinations thereof.

25

45. The method of Claim 37, wherein said step of providing a pile material comprises providing a textile fabric.

46. The method of Claim 37, wherein at least some of said
5 pile yarns comprise a thermoplastic material, and said step of
treating comprises treating the material at a temperature greater than
a heat set temperature for the thermoplastic material, to thereby
provide a durable pattern to the fabric.

10